

Amendments to the Specification:

Please amend page 1, paragraph 1 with the following paragraph:

The invention relates to a method for the production of a cooled ring insert ~~in accordance with the preamble of claim 1~~ consisting of a gray casting alloy having a nickel content, for an aluminum piston of an internal combustion engine. This is produced by using the casting method, having a cooling channel formed on the ring insert back, as a turned groove that is open towards the bottom.

Please amend page 3, paragraph 1 with the following paragraph:

This problem is solved with ~~a~~ the following method for the production of a cooling ring insert ~~having the characteristics according to the characterizing part of claim 1.~~ : (1) salt granulate is pressed into the turned groove at a pressure of 100 to 300 N/mm², so that a salt core is formed in the turned groove; (2) the combination consisting of the ring insert and the salt core is pre-heated to a temperature of 200°C to 250°C; and (3) the combination consisting of the ring insert and the salt core is dipped into an alfin bath consisting of an aluminum melt.

Because the turned groove worked into the back of the ring insert serves as a form into which the salt granulate for forming a salt core is pressed, the salt core takes on the precise shape of the turned groove, so that no cavities of any kind can form between the salt core and the turned groove.